

Work Order ID 162461

162461

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Tuesday, June 06, 2017 4:57:33 PM

Item ID:	D2565-111	Accept	*N900040100*	Setup	Start	*NS1*
Revision ID:					Stop	*NS2*
Item Name:	Strut					
Start Date:	5/30/2017	Start Qty: 6.00	*6*	Cust Item ID:		
Required Date:	6/16/2017	Req'd Qty: 6.00	*6*	Customer:		
Reference:						
Approvals:	Process Plan: 	Date: 	Tooling:		Date:	
	QC:	Date:	SPC (Y/N):		Date:	
				Run	Start	*NR1*
					Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2565	Rev E								
100	Punch ends and deburr as per dwg	0.11							
100	NC BRAKE				DAS 30 9-89	6			JUN 27 2017
Brake NC	Memo	1.92							
Brake NC	Punch as per Dwg D2565 using DT 8313								
110	Small Fab	0.00							
110	Small Fab				DAS 30 9-89	6			JUN 27 2017
Small Fab	Memo	0.71							
Small Fab	Deburr								
120	QC5- Inspect part completeness to step on W/O	0.00							
120	QC					6			DAS 38 9-89
Quality Control	Memo	0.12							JUN 27 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
341 06 345				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

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Tuesday, June 06, 2017 4:57:33 PM

Item ID: D2565-111 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Strut
 Start Date: 5/30/2017 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 6/16/2017 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per OSI005 4.3-Steel <i>M137176</i> Memo START TIME: <i>16:45</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>11:15</i>	0.00 0.36				<i>6</i>	<i>6/7-06-29</i>	<i>238</i>	
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.06				<i>6</i>	<i>JUL 03 2017</i>	<i>DAS 38</i>	
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <i>8X354</i> Memo	0.00 0.06				<i>6x</i>	<i>DAS 26 9-88</i>	<i>JUL 03 2017</i>	

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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Reference:

Stop ***NR2***

0.60

Quality Control



JUL 03 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

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Work Order ID: 162461

162461

Parent Item: D2565-111

D2565-111

Parent Item Name: Strut

Start Date: 5/30/2017

Required Date: 6/16/2017

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: E01.06.04Added Powder Coat, Removed Polish, and Added Inspection
Levels 3 & 21 EC
IPP: E06.05.03 Change level 2/8 to QC5 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased				100	f	164.7320	1.1375	184211			
M304TR0 750W 049										**			
304 RD Tube .750 x .049W										30			
										9.89			

JUN 27 2017

Location

Loc Qty

Loc Code

GA002

164.7319922

M135709

0.0000037

M136943

0.000158

M137091

0.3065145

M137286

44.417316

M137415

19.496

M137477

40.512

M137623

60

7.2

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Misidentified ☐	Past Due ☐																																																														

1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL

(REF DART SPEC. M304TRO.750W0.049)

ENSURE SEAMLESS TUBE IS USED

2) FINISH: POWDER COAT WHITE (4.3.5.2) PER PART QSI 005 4.3
3) TOLERANCES PER PART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES

(4) ALL DIMENSIONS ARE IN INCHES

NO WORK ORDER WITHOUT NOTICE

SUBJECT TO AMENDMENT

UNCONTROLLED COPY

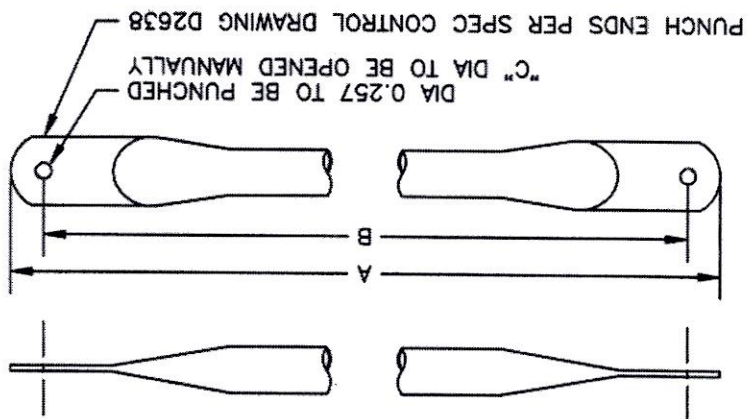
ENGINEERING RETURN TO SHOP COPY

102467

D2565-4
D2565-4
D2565-4
D2565-4
D2565-4
D2565-4

20170607

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-105	18.21	17.41	0.316
D2565-103	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-



DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		DRAWING NO. D2565	REV. E SHEET 1 OF 1	DATE 04.05.05		STRUT SCALE 1:3	
DESIGN		DRAWN BY 	APPROVED 		CHECKED	NEW ISSUE	
						CORRECT D2565-111 DIM. A	
C		98.10.05		UPDATED MATERIAL NOTE (TSR A603)		D	
D		02.06.05		ADD -3XX PARTS; ADD FINISH		E	
E		04.05.05		ADD D2565-401-411; RMV ANGLE D			

RELEASED 04.05.05

**DART**

DQA: _____ Date: _____

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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					